

Work Order ID 57162

March 24, 2010 8:53:23 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	24/03/2010	Start Qty:	1.00			
Required Date:	31/03/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10-3-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2221	Rev H								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: <u>M113328</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

SM 10/08/26 (14)

BE 10.08.26

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date:	31/03/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to								

1ST COAT:
 START TIME: 10:15
 OVEN TEMPERATURE: 400°
 FINISH TIME: 10:45
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: A/A
 OVEN TEMPERATURE:
 FINISH TIME:

① BR 10-8-27.

1 BR 10-8-27.

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Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 31/03/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

ml 10 08 30 ①

150

Identify as per dwg & Stock Location: *C.A*

0.00



Packaging

Memo

0.00

Packaging

w/o 57166

EP 10/08/30 @

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/30 J

B/10-8-30 @

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Parent Item: D2221

Parent Item Name: 350 Basket Base




Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2221-1	Manufactured	No	100	Each	9.0000	1.0000		B61091 B60575 ① NY 10/08/24
Rib								
	<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
	<u>Location</u>							
	Main Warehouse							
	WA			9				
	48101			1				
	55977			8				
✓ D2221-5	Manufactured	No	100	Each	4.0000	2.0000		B60173 ② NY 10/08/24
Rib								
	<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
	<u>Location</u>							
	Main Warehouse							
	WA			4				
	55652			4				
✓ D2221-7	Manufactured	No	100	Each	2.0000	1.0000		B60575 ① NY 10/08/24
Rib								
	<u>Warehouse</u>			<u>Loc Qty</u>		<u>Loc Code</u>		
	<u>Location</u>							
	Main Warehouse							
	WA			2				
	55651			2				

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item Name: 350 Basket Base

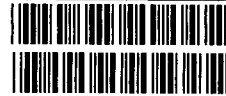
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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00



✓ D2232-3 Manufactured No 100 Each 15.0000 2.0000
 Basket Hinge
 B60831 @ 10/08/24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

15

50024

2

54863

13

✓ D2235-1 Manufactured No 100 Each 17.0000 2.0000
 Basket Rib
 B60274 @ 10/08/24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

17

50565

3

55979

4

56472

10

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Shop Packet Print

Page 2

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Start Date: 24/03/2010

Required Date: 31/03/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2581 Manufactured No 100 Each 35.0000 2.0000



Mounting Bracket



B60198 @ 14/10/08/24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

35

46086

2

48428

1

50872

1

51120

2

51745

2

55918

27

✓ D3442-1 Manufactured No 100 Each 29.0000 2.0000



Shim



B60177 @ 14/10/08/24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

29

46767

1

54071

9

56579

19

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Shop Packet Print

Page 3

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Required Date: 31/03/2010

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 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041



Rib Assembly (Basket End)

Manufactured No

100

Each

8.0000

2.0000



B60838 ② 10/08/24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

8

54865

2

56205

6

✓ D3826-041



Rib / Gusset Assembly

Manufactured No

100

Each

6.0000

2.0000



B60670 ② 10/08/24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

6

56207

6

✓ D3827-041



Rib Assembly (Inboard)

Manufactured No

100

Each

9.0000

1.0000



B60445 ① 10/08/24

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

9

54866

3

55982

6

March 24, 2010 8:53:27 AM

Shop Packet Print

Page 4

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 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Start Qty: 1.00

Required Qty: 1.00

✓ D3832-1 Manufactured No 100 Each 3.0000 1.0000



Mesh (Base)



B 61022 ① M 10/08/26

Warehouse
Location

Main Warehouse

WA 3

56179 3

✓ D3833-1 Manufactured No 100 Each 13.0000 2.0000



Mesh (Base End Face)



B 60448 ② M 10/08/26

Warehouse
Location

Main Warehouse

WA 13

50025 2

55843 3

56396 8

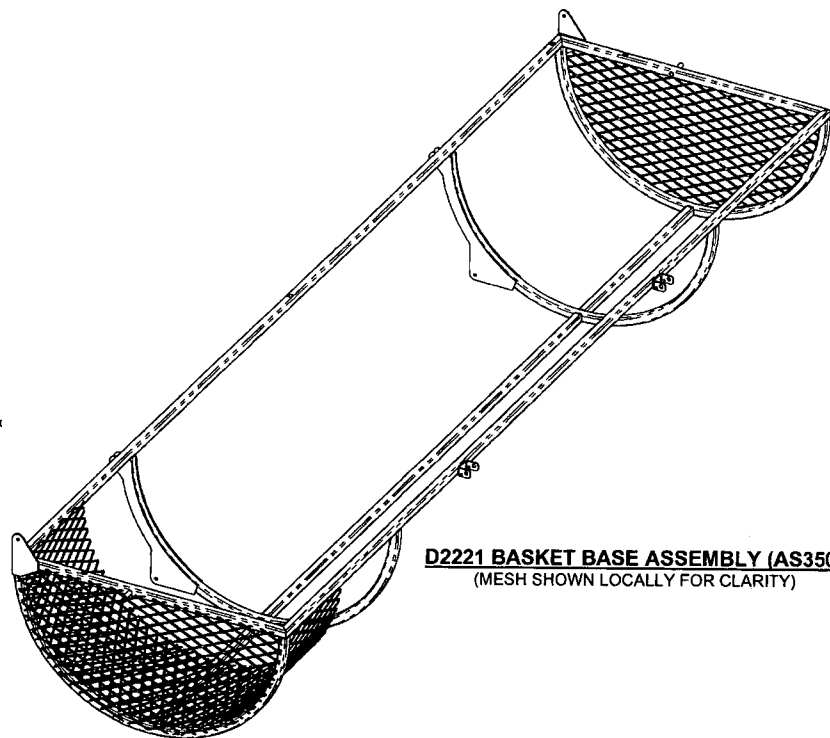
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 57162
Bj10-3-29

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW REF (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	85.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

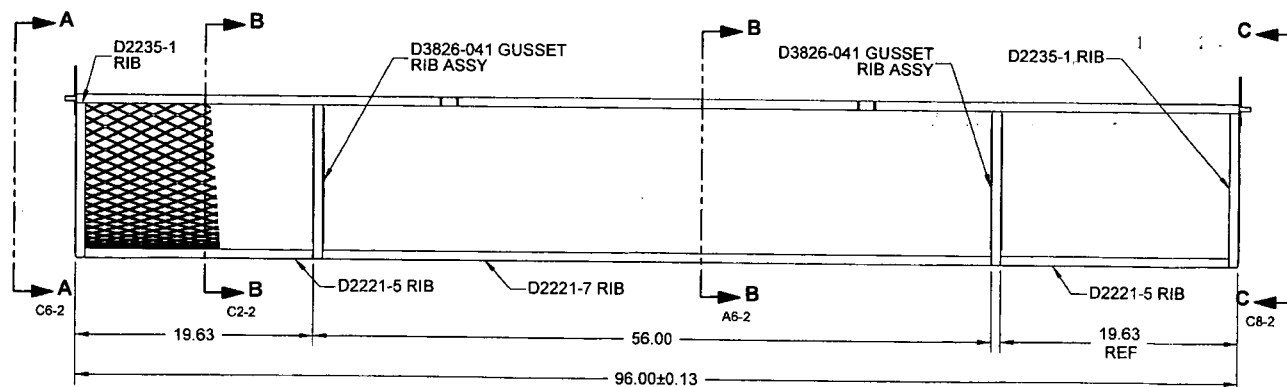
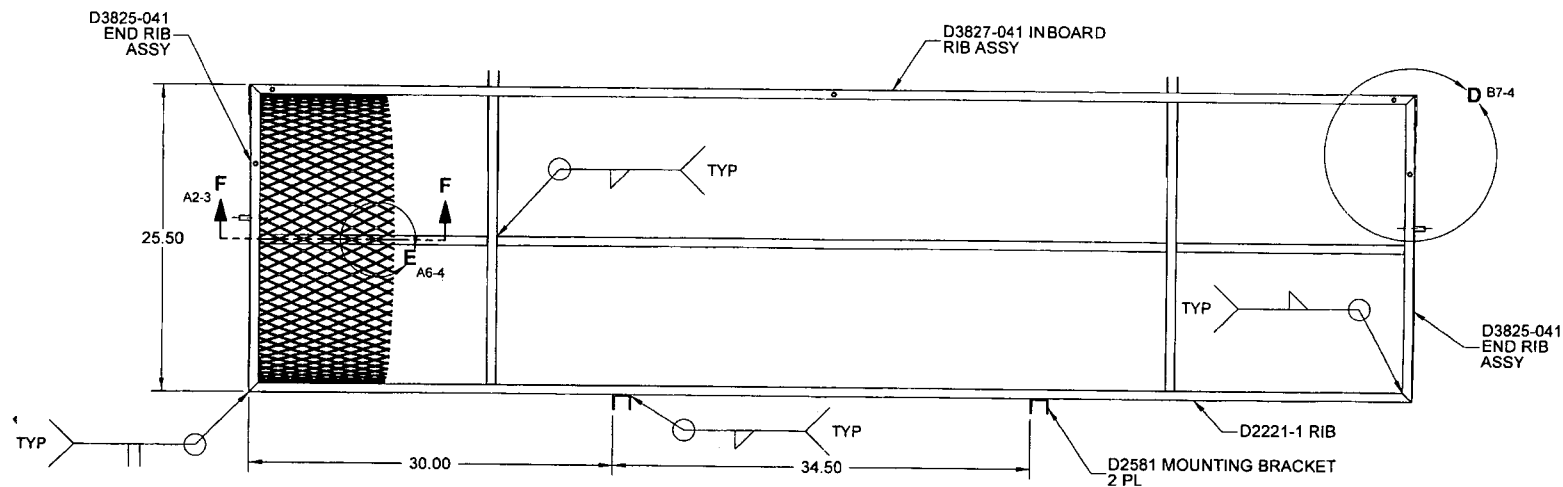
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NAD

37142

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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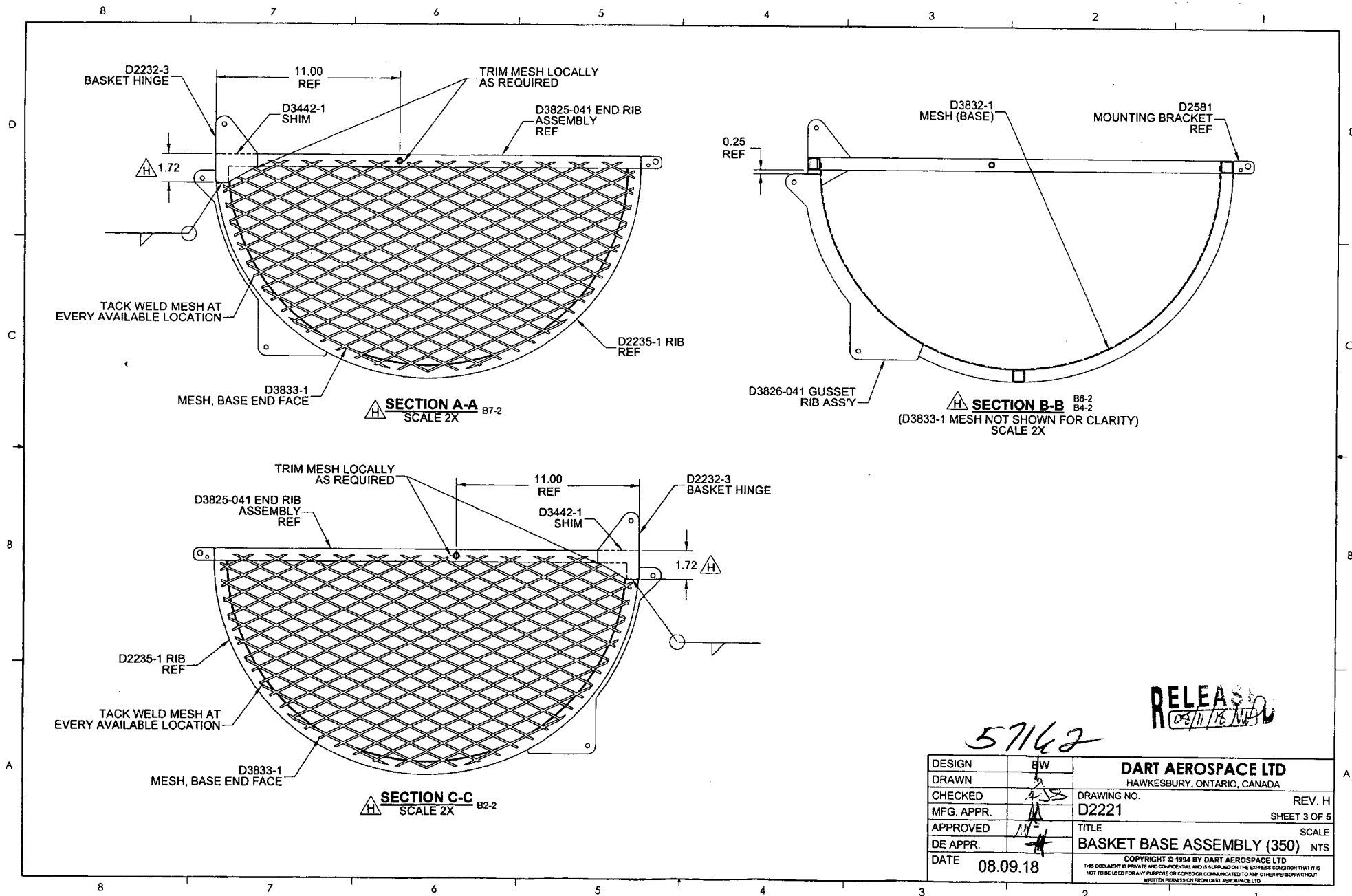
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RELEASED

57162

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 3 OF 5	
APPROVED	MA	TITLE	SCALE
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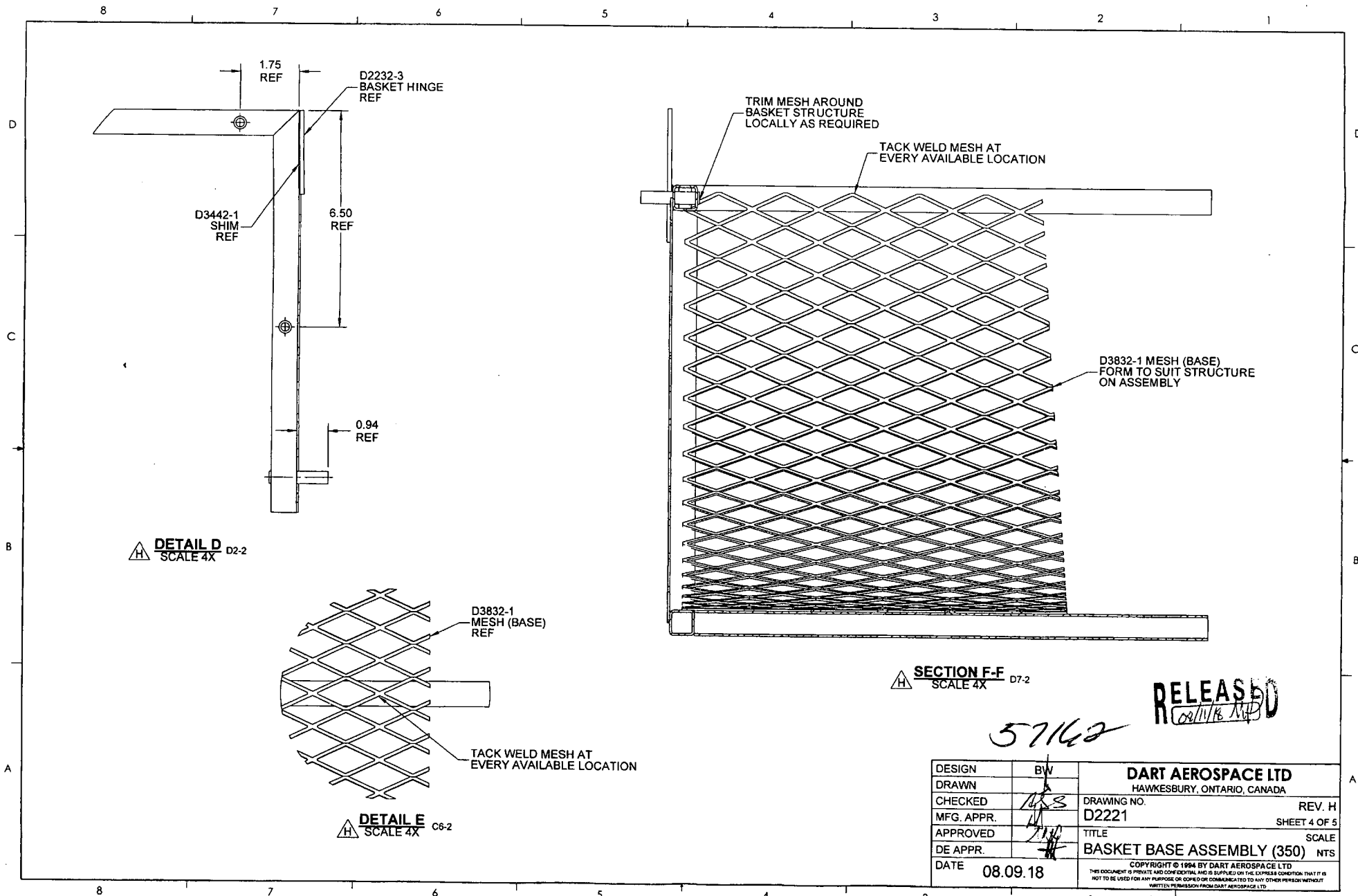
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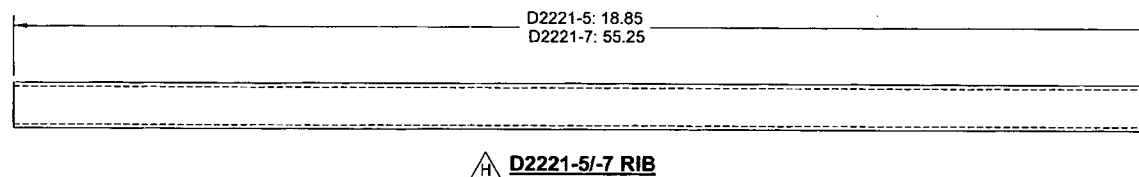
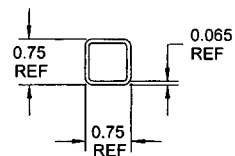
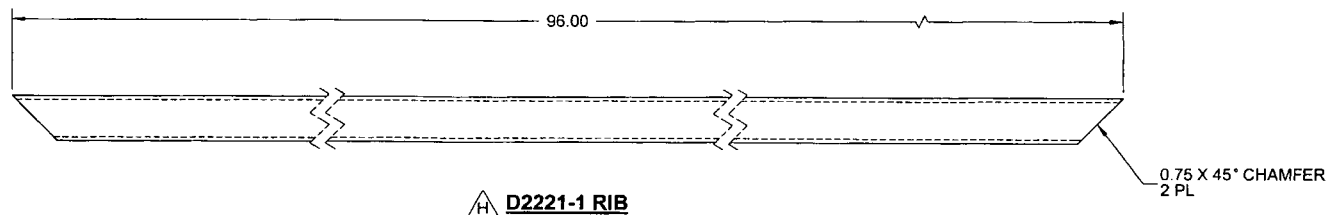
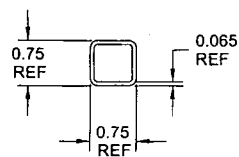
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08/11/18

57162

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries